



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-14181W4-13
Job Sheet 200894



Part No: RBE105-14181W4-13

Job Qty: 5 pcs

Part Name: Screw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/18/19

Job Tracking No:

Due Date: 11/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-14181W4 Rev C IPP Rev. A 19.01.11 New issue DP Verify DD/IPP Rev. B 19.09.09 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-2500Y - 1	5 pcs	11/7/19	11/7/19	1.00	6.67	SL-2500Y - 1		
110	QC 2	5 pcs	11/7/19	11/7/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S225794

www.



Part: RBE105-14181W4-13

Job No: 200894

Serial No/Batch: S225794

Revision: C

Inspector:

Exp Date:

Instructions:

120	QC 8	5 pcs	11/7/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	DAS
					QC 8 - 52	23
					QC 8 - 23	9-89 19/10/24
					QC 8 - 57	
					QC 8 - 76	
130	Outsource - 12 - Black Oxide	5 pcs	11/7/19		GRO002-VC	2019-10-24
140	Packaging 2-1 - Receive - B4B	5 pcs	11/7/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
150	QC 6	5 pcs	11/7/19	0.00 0.00	QC 6 - 9	

9/19/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

DAS
68
9-89

NOV 07 2019

				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
160 Packaging 3-1 - Stock - B4B	5 pcs	11/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	ALL
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
170 QC 21 - SA	5 pcs	11/7/19	0.00 0.00	QC 21 - SA - 21	NOV 08 2019
				QC 21 - SA - 70	
Part Op 100 - 1-Machine as per folio FC643 FOLIO REV: <u>AA</u> DWG REV: <u>C</u> 2-Deburr 3-Apply LPS-3 to ALL Descriptions: steel parts 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - -Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required 140 - (Receive & Inspect for Damage & Mat'l Certs) Certificate of Conformity is required 150 - QC6- All purchased or subcontracted products 160 - Identify as per dwg & Stock Location: _____ 170 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-4140QT-R1.500	AISI 4140 Quenched & Tempered Steel Round Bar 1.500" Dia. 3.2500 ft (.65 ea)	100-SL-2500Y - 1		100-SL-2500Y - 1 588342 5X8 1/16	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-SL-2500Y - 1	MT-4140QT-R1.500	3	5	0	
Part Specifications					
Specifications could not be found.					

Plex 9/18/19 1:43 PM Dart.lajeunesse.marie

DART AEROSPACE LTD	Work Order:	200894
Description:	Part Number:	RBE105-14181W4-13
Inspection Dwg: Same as Part #	Rev:	Page 1 of 1

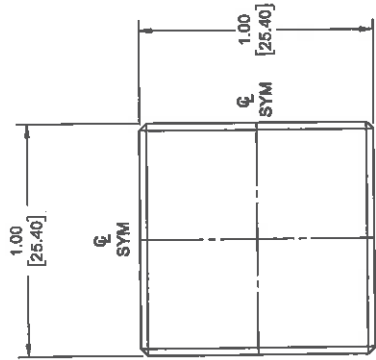
INSPECTION SHEET

[illegible]

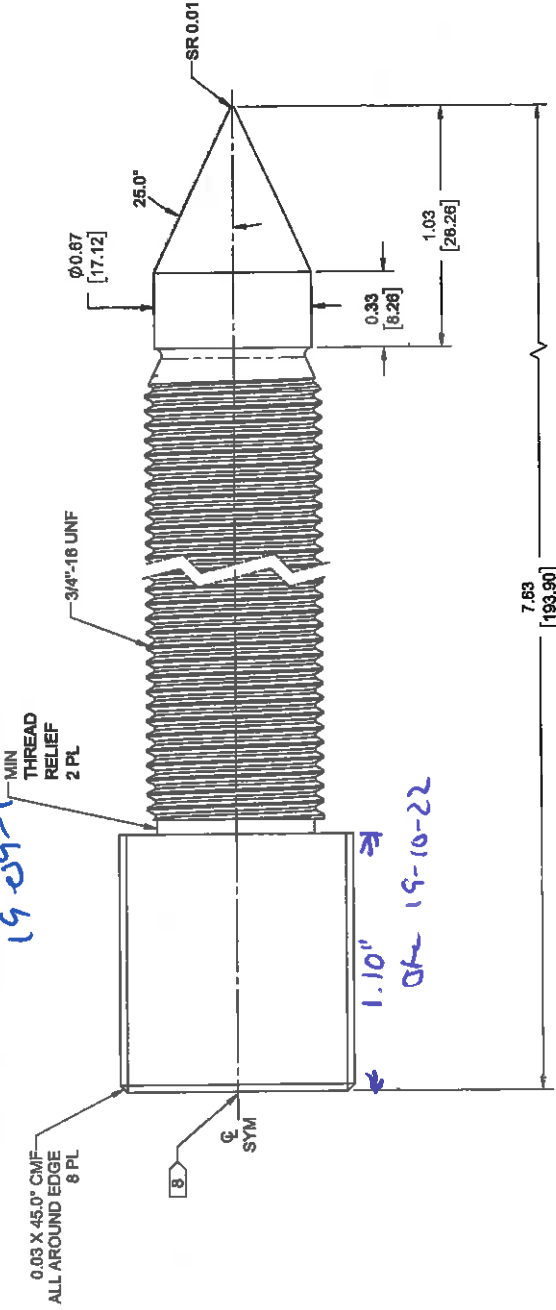
Measured by:		Checked by:	 23 9-89	QC Inspector:	
Date:	20/9/10/23	Date:	19/10/24	Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



RBE105-1418IW4-13 SCREW



- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF MIL-C-13924 CLASS 2 OR MIL-C-13924 CLASS 3 OR MIL-C-81309 TYPE III
 - 4) TOLERANCES:
X.XX = ± 0.01 "
X.XXX = ± 0.001 "
X.XXX = ± 0.005 "
X.XXXX = ± 0.0005 "
X.XXXXX = ± 0.0001 "
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) CENTER DRILL IS ACCEPTABLE



Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐
Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (Q51042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐
Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: _____

Tel (613) 632-5200

PURCHASE ORDER
POHB044883



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-8868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PQ No: POHB044883

PO Date: 10/24/19

Due Date: 11/1/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60**Freight Terms:****Special Comments:**

E-MAIL
2019-10-23

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200295	RBE350A94-3700-A-05	RBE350A94-3700-A-05 Rev 7	Foot -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/1/19	30 pcs	0 pcs	30 pcs	\$2.80/pcs	\$84.00
	200274				Firmed	-	11/1/19	30 pcs	0 pcs	30 pcs	\$2.80/pcs	\$84.00
								Sub Total:	60	0	60	\$168.00
2	200894	RBE105-14181W4-13	RBE105-14181W4 Rev C	Screw -Issue P/O -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type 4140 -Certificate of Conformity is required	Firmed	-	11/1/19	5 pcs	0 pcs	5 pcs	\$4.92/pcs	\$24.60
Grand Total:												\$192.60

Lucien

10/28/2019

PURCHASE ORDER



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

PURCHASE ORDER
POHB044883



Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/28/19 10:15 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(023558-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

023558 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
01-Nov-2019		Jigar Patel				POHB044883				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order	
1	RBE350A94-3700-A-05 Rev.7	RBE350A94-3700-A-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1		OXIDE-BLACK CH	30	30	0	0	0	
2	RBE350A94-3700-A-05 Rev.7	RBE350A94-3700-A-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1		OXIDE-BLACK CH	30	30	0	0	0	
3	RBE105-14181W4-13 Rev.C	RBE105-14181W4 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309, TYPE - 3 OR MILL - C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS OIL		OXIDE-BLACK CH	5	5	0	0	0	

NO.

DAS 68 9-85

RECEIVED
NOV 05 2019
DART AEROSPACE LTD.

DAS
68
9-89

RECEIVED
 NOV 05 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.